

Date: Thursday, 2/23/2006 10:24:23 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOLDING STEP WELDMENT **RH**  
 Job Number : 25927  
 Estimate Number : 10697  
 P.O. Number : N/A Part Number : D3388042  
 This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D3388 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : A  
 Previous Run : 25874 Material : N/A  
 Due Date : 3/28/2006 Qty: 3 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est. B 05.06.10 Added Step 11 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

D2622-120C extrusion

Batch: 324563

KE 06.03.21 3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CUT D2622-120C extrusion 85.15" long as per Dwg D3388

Deburr and bevel ends for welding

KE 06.03.21 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>324402</u>

KE 06.03.21 3

4.0 D33872 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<u>326162 = (2)</u> <u>324120 = (2)</u> <u>325934 = (2)</u>

KE 06.03.22  
KE 06.03.24 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 24/05/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 25927

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

KE 06.3.24 1  
KE 06.3.22 2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06.03.26 3 PTO see last page

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.4

Wing Walk as per Dwg D3388 and QSI 005 4.4

Powder coat gloss white  
As per QSI 005 4.3 (0.5.1)

FC 060413 3  
DC 060413 3

8.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808 Spacer

Press spacer into D3387-2 arm as per Dwg D3387

~~D2808~~ B25248

SAD 06104122 3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.04.23 3

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06:05:16 3

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 060511 3  
U 060511

**Dart Aerospace Ltd**

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**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

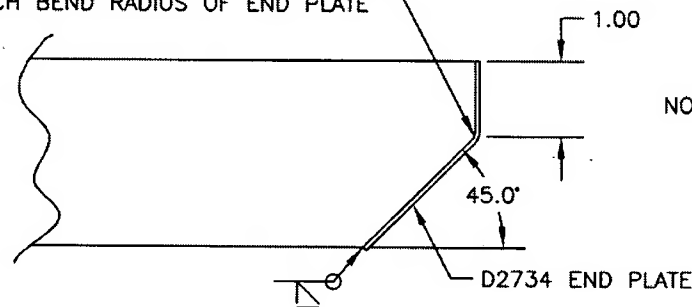


RELEASED

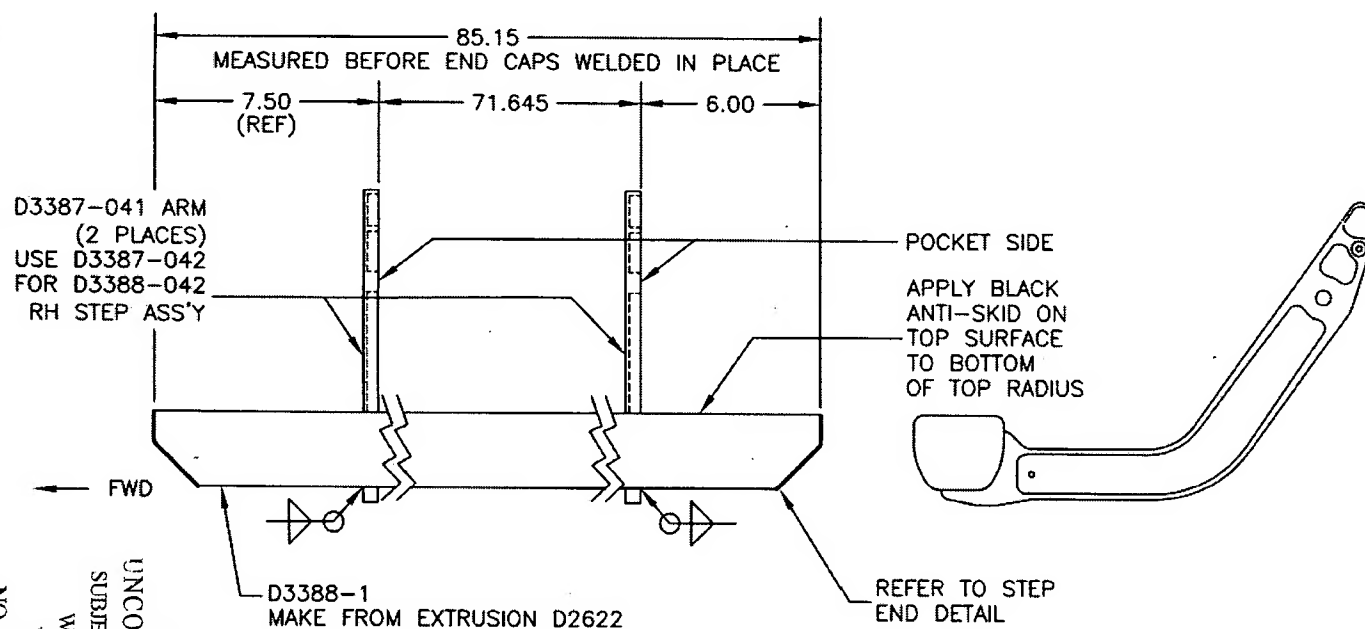
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE



D3387-041 ARM  
(2 PLACES)  
USE D3387-042  
FOR D3388-042  
RH STEP ASS'Y

POCKET SIDE  
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

REFER TO STEP  
END DETAIL

D3388-1  
MAKE FROM EXTRUSION D2622

**D3388-041 LH STEP ASSEMBLY (SHOWN)**  
**D3388-042 RH STEP ASSEMBLY (OPPOSITE)**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2. WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
3. FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 25927

ENGINEERING  
RETURN TO  
SHEPHERD

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

REV. A

SHEET 1 OF 1

SCALE

NTS

TITLE  
STEP WELDMENT

A

05.01.20

NEW ISSUE

DESIGN

DRAWN BY

CHECKED

APPROVED

DRAWING NO.

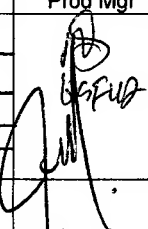
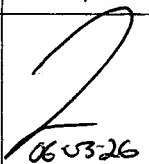
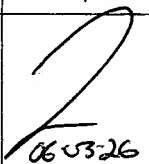
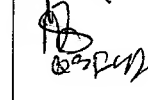
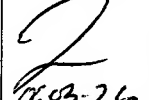
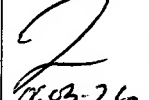
D3388

DATE

05.01.20

05.01.20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.03.26	6.1	Weld 2nd end cap AS per DWG 03388 Inspect Alodine QC 3	FF 06.04.05	06.04.03	3	 		
06.03.26	6.2	Weld 2nd end cap AS per DWG 03388, And grind welds flush. Inspect for foreign objects.	06.04.04	3				
06.03.26	6.3	Inspect QC 5/9	06.04.06 (3)	3				
06.03.26	6.4	Touch-up end cap with alodine as necessary as per Q51005 4.1	06.04.08	3				
		change muscle						
06.03.26	7.	Make change to powder coat white permanent change				 		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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